

Date: Thursday, 12/21/2006 12:01:56 PM
User: Kim Johnston

Process Sheet

split ① *KE*

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY
Job Number : 30068
Estimate Number : 11672
P.O. Number : *NA*
This Issue : 12/21/2006 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : LARGE FAB ASSY
Previous Run : 28391
Part Number : D350591121
Drawing Number : D2351 REV E
Project Number : N/A
Drawing Revision : E
Material : *N/A*
Due Date : 1/20/2007 Qty: *1* Um: Each
Written By : *JA*
Checked & Approved By : *JA 06 12 21*
Comment : Est Rev: 02.10.21 Re-format; Incorporated D2351-041 IPP K
J/RF
est rev. F 06.02.23 added grinding EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-121CHG003

2.0 D2244116 Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.5000 Each(s)

Pick:

Qty Part Number Description Batch

0.5 D2244-128 Extrusion

*B 23404 ⑤**B31406**R28216 ②**Rework**FF 07-02-28*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

FF 07-02-28

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

FF 07-02-28

4.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend per Dwg D2351 using Bend Program D23561dD FT011

*DP/EL**07/03/06*

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Drawing Name: SHORT STEP ASSEMBLY

Job Number: 30068

Part Number: D350591121

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/03/12 (3)

6.0	D28501	End Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
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1	D2850-1	End Bracket	326919
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07-03-31

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/R Aluminum Rod M100237
M102225

3-Do not Grind Flush

07-03-31
07-03-31
07-03-31

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

07/04/02

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07-02

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-04-02

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/04/02

Date: Thursday, 12/21/2006 12:01:56 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 30068

Part Number: D350591121

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2582

Step Leg Assy

B29422

P.E. 07.04.02 1

13.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W3

Rivet

B14393

P.E. 07.04.02 1

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

P.E. 07.04.02 1

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/02

16.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2673-34 End Plate

B25396

P.E. 07.04.02 1

17.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R

Aluminum Rod

M100237

2-Grind end cap flush per dwg D2351

P.E. 07.04.02 1

P.E. 07.04.02 1

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 30068

Part Number: D350591121

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/02 ①

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/02 ①

20.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

LD

07-04-02 ①

21.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m103706

FL

07/04/02 ①

22.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per Dwg D2351 and QSI 005 4.4

Batch: m103707

FL

07/04/03 ①

23.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/04/03 ①

24.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

25.0 D22301 Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch
1 D2230-1 Mounting Lug 30155

07/04/03 SQ

Date: Thursday, 12/21/2006 12:01:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY

Job Number: 30068

Part Number: D350591121

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D22303

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch
1 D2230-3 Mounting Lug B30545

27.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 3.0000 f(s)

Pick:

Packing KitQty Part Number Description Batch
1 D2856-400 7.20" Abrasion Strip B29850

28.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch
2 AN3-37A Bolt M103926

29.0

AN413A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

AN4-13A

Batch: M102989

30.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch
4 AN960JD10 Washer M100274

31.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch
6 AN960JD416 Washer M102929

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Drawing Name: SHORT STEP ASSEMBLY

Job Number: 30068

Part Number: D350591121

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 MS21042L3 Nut (or -3) *M102277*

33.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 MS21042L4 Nut (or -4) *M103914*

02/04/03 SD

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-121

Location: _____

PPP Rev: _____

02/04/03

36.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

02/04/03

Job Completion



02/04/04

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30068

RELEASED
05.11.28 #

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Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT STEP ASSEMBLY
Job Number : 30068	
Estimate Number : 11672	
P.O. Number :	
This Issue : 12/21/2006 S.O. No. :	Part Number : D350591121
Prsht Rev. : NC	Drawing Number : D2351 REV E
First Issue : 1/1	Project Number : N/A
Previous Run : 28391	Drawing Revision : E
	Material :
	Due Date : 1/20/2007
Written By : <u> </u>	Qty: 5 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev. E 02.10.21 Re-format, Incorporated D2351-041 IPP K	
J/RF	
est rev. F 06.02.23 added grinding EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Photocopy bluefile and type labels as per PPP D350-591-121CHG003

06.12.21

2.0	D2244116	Step Extrusion
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.5000 Each(s)

Pick:

Qty	Part Number	Description	Batch
0.5	D2244-128	Extrusion	

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

REFERENCE ONLY

4.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend per Dwg D2351 using Bend Program D23561dD FT011